

Work Order ID 84026

84026

Page 1

May-01-12 10:45:28 AM

Item ID: D3874-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Floor Protector
 Start Date: 01/05/2012 Start Qty: 5.00 ***5*** Cust Item ID:
 Required Date: 15/05/2012 Req'd Qty: 5.00 ***5*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/05/02 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3874	Rev A								
100		0.00							
100									
HandThermo	Memo	0.00							<u>B 12/05/10</u>
Hand Finishing Thermoforming	1-Cut Sheet to required Blank size								
105		0.00							
105	Dry Material								
HandThermo	Memo	0.00							<u>B 12/05/10</u>
Hand Finishing Thermoforming	Dry Sheet as per QSI022 POLYCARBONATE								
	Temp: <u>240</u>								
	Time IN: <u>4:30</u>								
	Time OUT: <u>7:00</u>								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 *110* Thermoform Thermoforming Machine	Memo 1-Machine Set-Up 2-Pre-heat Tool to required temp. 3-Thermoform as per Dwg and Folio #FTA038 using tool DT9474 Dwg Rev: <u>A</u> Folio Rev: <u>B</u>	0.00 0.00				<u>5</u>			<u>B</u> 12/05/10.
120 *120* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo Visually inspect part for proper formation and texture	0.00 0.00				<u>5</u>			<u>B</u> 12/05/10.
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				<u>5</u>			<u>U</u> 12/05/10.

Dart Aerospace Ltd

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Item ID: D3874-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Floor Protector

Stop *NS2*

Start Date: 01/05/2012 **Start Qty:** 5.00

5

Cust Item ID:

Required Date: 15/05/2012 **Req'd Qty:** 5.00

5

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID

Tool #

Plan
Code

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

170

Identify as per dwg & Stock Location: _____

0.00

170

Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00

180


QC

Memo

0.00

Quality Control

5 5 a 12/05/14

12/5/15 

mf
12-05-15

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Picklist Print

May-01-12 10:45:32 AM

Page 1

Work Order ID: 84026

84026

Parent Item: D3874-1

D3874-1

Parent Item Name: Floor Protector

Start Date: 01/05/2012

Required Date: 15/05/2012

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev A 09.02.06 New Issue DL
Add Step 105 Dry Material 10/04/21 DL

IPP Rev B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.118-90318-08		Purchased	No			100	sf	1,290.266	4.38	21.9			

MI FXS 118-90318-08

Lexan Sheet

**

Location

therm

Loc Qty

1290.266941

Loc Code

1290.26694

113127

21.9 sq ft

DL
12/05/14

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	84024
Description: Floor Protector		Part Number:	D3874-1
Inspection Dwg: D3874	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than $\frac{1}{8}$ "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by:	DL	Date:	12/05/10.
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TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.050	Min	0.098"	✓		Visual DL-02	
0.065	Min	0.105"	✓		CAL TH-DT	
0.5	Min	0.55"	✓		CAL TH-DT	
21.8	REF	21.875"	✓		TAPE DL-01	

Measured by:	DL	Date:	12/05/14
Audited by:	SD	Date:	12/05/14
Prototype Approval:	N/A	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.09.15	New Issue	KJ	MA

W/O:		WORK ORDER CHANGES					
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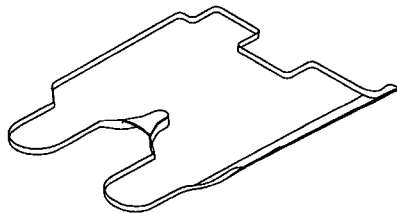
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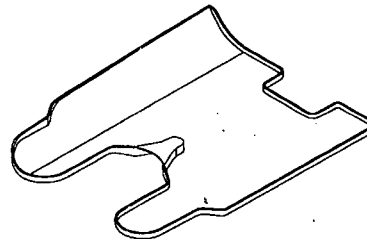
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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 84024 *PL12-05-2*



D3874-1 FLOOR PROTECTOR



D3874-2 FLOOR PROTECTOR

RELEASED
29/05/05

A	NEW ISSUE	PH	09.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>PH</i>		
CHECKED	<i>PH</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>PH</i>	D3874	SHEET 1 OF 3
APPROVED	<i>PH</i>	TITLE	SCALE
DE APPR.	<i>PH</i>	FLOOR PROTECTOR	NTS
DATE	09.01.29	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

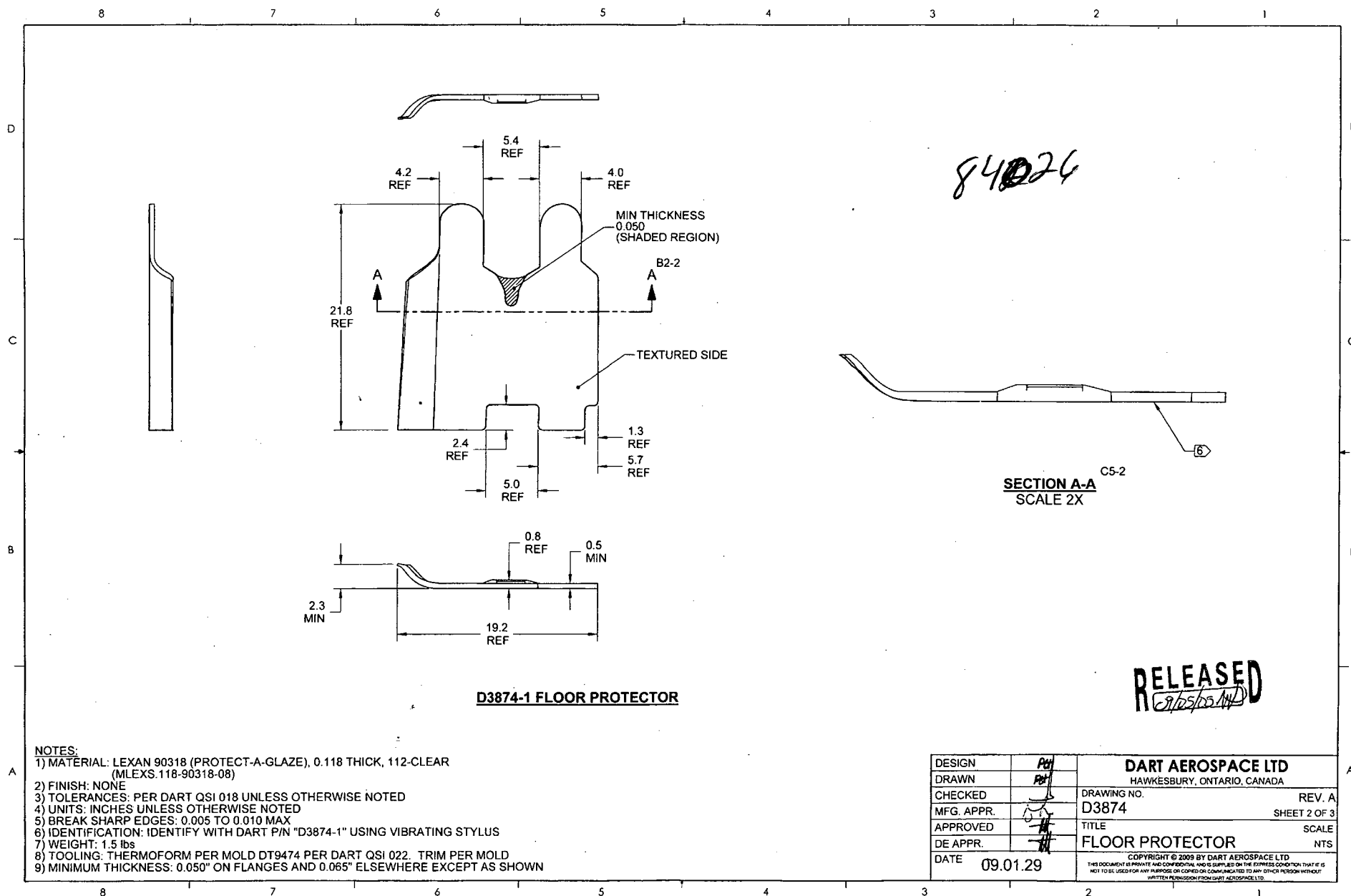
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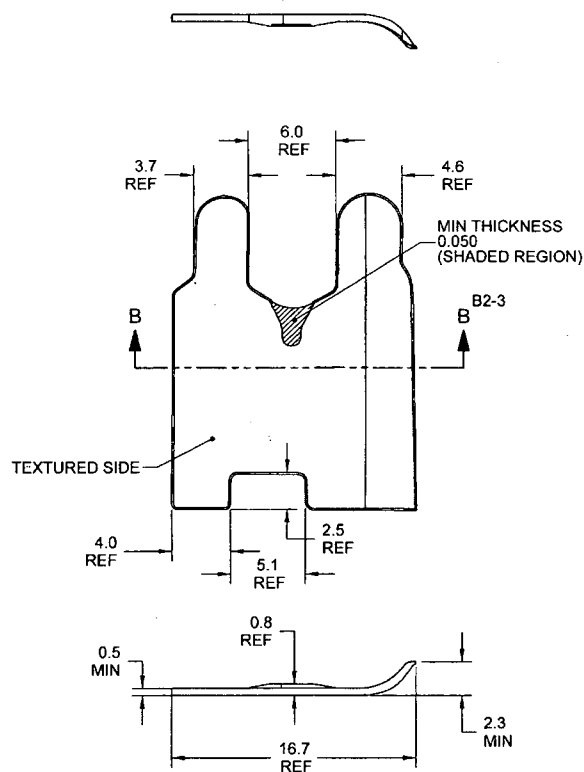
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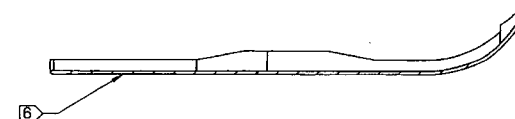


D3874-2 FLOOR PROTECTOR

NOTES:

- 1) MATERIAL: LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS.118-90318-08)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3874-2" USING VIBRATING STYLUS
- 7) WEIGHT: 1.5 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9474 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" ON FLANGES AND 0.055" ELSEWHERE EXCEPT AS SHOWN

84026



SECTION B-B
SCALE 2X

RELEASED
28/05/03

DESIGN	PA	DART AEROSPACE LTD	
DRAWN	PA	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PA	DRAWING NO. D3874	REV. A
MFG. APPR.	PA	SHEET 3 OF 3	
APPROVED	PA	TITLE FLOOR PROTECTOR	SCALE
DE APPR.	PA	NTS	
DATE	09.01.29	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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